



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5953
Job Sheet 203127



Part No: D5953

Job Qty: 4 pcs

Part Name: Saddle



Part Weight: 0 lbs

Job Created: 11/11/19

Due Date: 11/25/19

Type: Stock

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG REV B IPP Rev:E Re-Format 05-11-29 JLM IPP Rev:f ecn 826 06.12.06 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	4 pcs	11/25/19		0.00	0.00	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
100	HAAS 4 Axis - B4B	4 pcs	11/25/19		0.79	10.53	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
110	QC 2	4 pcs	11/25/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		

582 19/4/14

582 19/11/12

DAS
23
9-89

DAS
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Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S230521



Part: D5953

Job No: 203127

Serial No/Batch: S230521

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/11/19

120 QC 8	4 pcs	11/25/19	0.00	0.00	QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130 Handfinish - 1-1 Chemical- B4B	4 pcs	11/25/19	0.00	0.40	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 -	

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							B4B	
							Handfinish - 1 - 13 - B4B	
							Handfinish - 1 - 14 - B4B	
							Handfinish - 1 - 15 - B4B	
							Handfinish - 1 - 16 - B4B	
							Handfinish - 1 - 17 - B4B	
							Handfinish - 1 - 18 - B4B	
							Handfinish - 1 - 19 - B4B	
							Handfinish - 1 - 20 - B4B	
							Handfinish - 1 - 21 - B4B	
							Handfinish - 1 - 22 - B4B	
							Powdercoat - 1 - B4B	
							Powdercoat - 2 - B4B	
140	Powdercoat - 1 White GI(A)- B4B	4 pcs	11/25/19	0.00	0.19		Powdercoat - 3 - B4B	
150	QC 3	4 pcs	11/25/19	0.00	0.00		Powdercoat - 4 - B4B	
							QC 3 - 10	
							QC 3 - 13	
							QC 3 - 15	
							QC 3 - 17	
							QC 3 - 18	
							QC 3 - 2	
							QC 3 - 28	
							QC 3 - 3	
							QC 3 - 30	
							QC 3 - 34	
							QC 3 - 36	
							QC 3 - 41	
							QC 3 - 51	
							QC 3 - 58	
							QC 3 - 59	
							QC 3 - 68	
							QC 3 - 9	
							QC 3 - 40	
							QC 3 - 19	
							QC 3 - 43	
							QC 3 - 24	
							QC 3 - 61	
							QC 3 - 81	
160	Packaging 3-1 - Stock - B4B	4 pcs	11/25/19	0.00	0.00		Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	
							Packaging 3 - 6 - B4B	
							Packaging 3 - 7 - B4B	
							Packaging 3 - 8 - B4B	
							Packaging 3 - 9 - B4B	
							Packaging 3 - 10 - B4B	
							Packaging 3 - 11 - B4B	

BK 19-11-18

M21586-
START 1:45 O.T. 3:00 FINISH 2:15

NOV 7 7 2019

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NOV 28 2019

ST399 (Oscar)

					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170 QC 21 - SA	4 pcs	11/25/19	0.00	0.00	QC 21 - SA - 21 ✓	379
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-05 NOV 28 2019

Part Op 100 - (HAAS CNC Vertical Machine), 1-Machine as per folio D5953,Ensure Batch Number is entered
Descriptions: 110 - Inspect on CMM as per folio CMMA017.
120 - (QC8- Inspect parts - second check)
130 - (Chemical Conversion Coat per QSI005 4.1)
140 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum), START TIME: _____
150 - (QC3- Inspect Part Finish)
160 - (Identify as per dwg & Stock Location: _____)
170 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	4 pcs (1 ea)	90-Machining - Issue SN	1x S204067 3x S228223
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Machining - Issue SN	D6101-007	4	23	0
Part Specifications				
Specifications could not be found.				

Plex 11/11/19 9:11 AM Dart.lajeunesse.marie

20312.7

DART AEROSPACE LTD		Work Order: <u>200425</u>
Description: Inner Fwd Saddle		Part Number: D5953
Inspection Dwg: D5953	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.749	1.749	1.749	1.749		
C	5.245	5.255		5.249	5.249	5.249	5.249		
D	6.995	7.005		6.999	6.999	6.999	6.999		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		0.315	0.316	0.316	0.316		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		0.315	0.316	0.316	0.316		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.501	0.497	0.497	0.497		
N	1.615	1.635		1.630	1.636	1.625	1.625		
O	7.990	8.010		7.998	7.998	7.998	7.999		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		0.311	0.311	0.311	0.311		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.497	0.497	0.496	0.501		
T	1.375	1.395		1.375	1.375	1.375	1.375		
U	2.000	2.020		2.000	2.000	2.000	2.000		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>[Signature]</u> Date: <u>19/11/12</u>	Audited by: <u>[Signature]</u> Date: <u>19/11/13</u>
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Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	
F	08.12.01	Dimension K revised	KJ/DD	

